

Work Order ID 73046

Wednesday, August 24, 2011 3:34:15 PM



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Item ID:	D2435	Accept		Setup	Start	
Revision ID:						
Item Name:	Bearpaw, 206				Stop	
Start Date:	8/25/2011	Start Qty:	8.00			
Required Date:	9/8/2011	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	<i>MY</i>	Date:	<i>11-08-24</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D2435								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-10-03

8

F.K. 11/10/26

F.K. 11/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2435	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bearpaw, 206				
Start Date: 8/25/2011	Start Qty: 8.00		Cust Item ID:	
Required Date: 9/8/2011	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00		ent 11/10/30		8	8		
151 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00		PPR 69046					ent 11/10/31 8
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							ent 11/10/01 8

mf
11-11-01

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Work Order ID: 73046



Parent Item: D2435

Parent Item Name: Bearpaw, 206


Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	414.2200	3.2	25.6			



BIT 10-03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	414.22	
117321	76.6	
117738	124.3	
117819	129.9	
118257	83.42	

118257

8

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DART AEROSPACE LTD		Work Order:	73046
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45				
B	5.500	+/-0.030	5.500				
C	0.200	+/-0.030	0.192				
D	R0.250	+/-0.030	0.250				
E	0.250	+/-0.010	0.255				
F	0.625	+/-0.030	0.632				
G	0.25 x 45°	+/-0.030	0.25 x 45				
H	0.375	+/-0.010	0.380				
I	19.000	+/-0.030	19.000				
J	0.950	+0.030/-0.010	0.954				
K	Ø0.260	+0.005/-0.000	0.260				
L	Ø0.930	+/-0.030	0.930				
M	0.30	+0.030/-0.000	0.313				
N	0.375	+/-0.030	0.380				
O	7.375	+/-0.030	7.375				
P	4.250	+/-0.010	4.255				
Q	2.000	+/-0.030	2.010				
R	9.000	+/-0.010	9.000				
S	15.750	+/-0.030	15.750				

Measured by:	<i>J.K.</i>	Audited by:	<i>and</i>	Prototype Approval:	N/A
Date:	11/10/20	Date:	11/16/30	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>+</i>	<i>+</i>

Dart Aerospace Ltd

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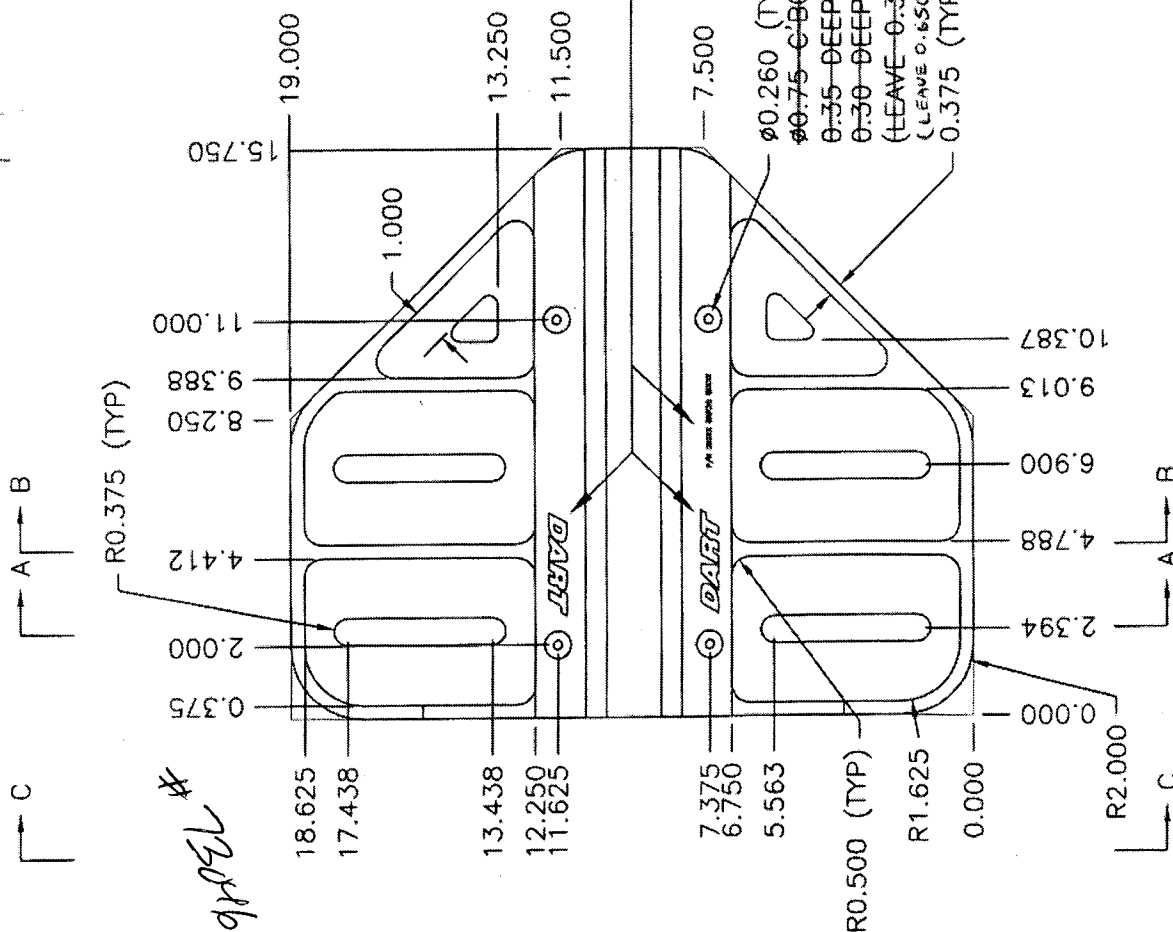
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>98</i>	APPROVED <i>98</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143

RELEASED
98.06.17 KEENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 $\phi 0.75$ C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

Dart Aerospace Ltd

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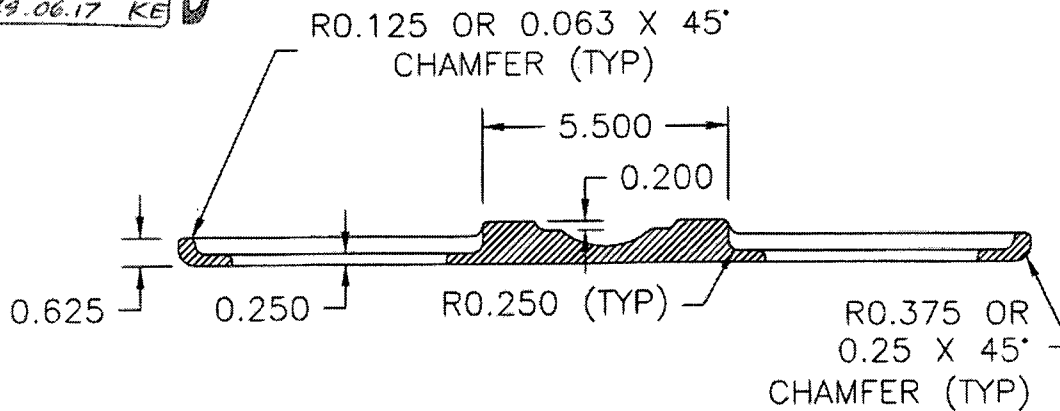
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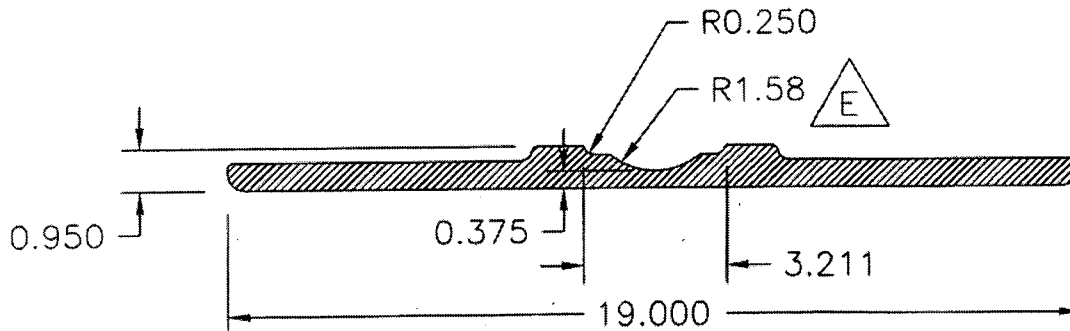


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE

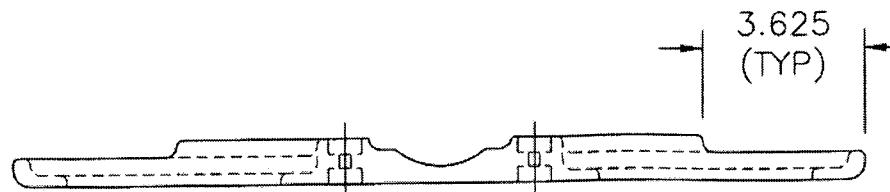


SECTION A-A



SECTION B-B

73046



SECTION C-C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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